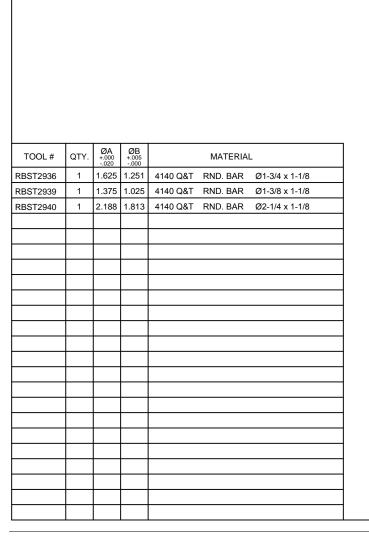


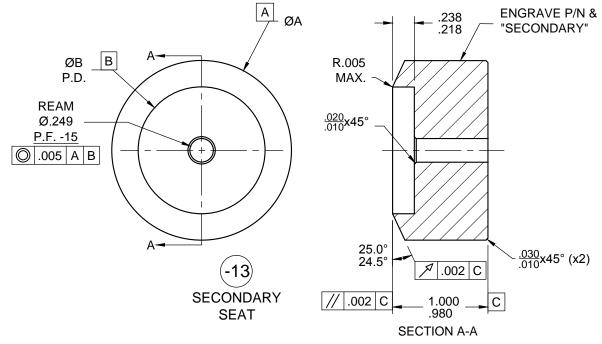
TOOL#	ØA +.000 002	PIN TYPE	QTY.		MATERIAL			
RBST2936	.372	Ш	2	1018	RND. BAR	Ø3/8 x 5/8		
RBST2939	.372	III	2	1018	RND. BAR	Ø3/8 x 5/8		
RBST2939	.622	III	2	1018	RND. BAR	Ø5/8 x 5/8		
						_		

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

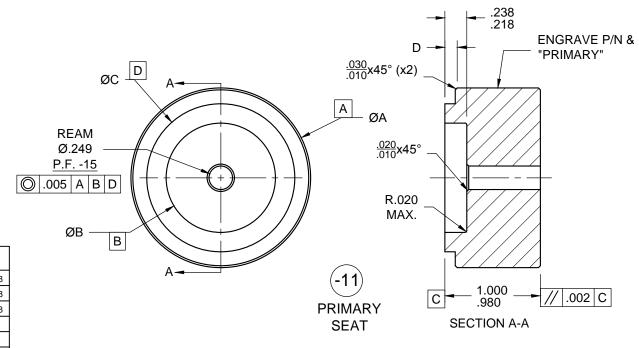
RE	RED	BARI	1 MA	ACH]	[NE	
™ERBS S\		SERIE: TOOL;				.ER
DWG NO.	TOOL#	(see	char	^t)-	15	REV 2
DIME	S OTHERWISE ENSIONS ARE IN S ON:		DRAWN BY: APPROVED	PE	RRITT	
DECIMALS .XXX ± .005 .XX ± .01 X ± .1	FRACII	ONS ± 1/32 GLES ±.5°	HEAT TREAT FINISH SPEC		K 🗆 XIDE	-
UNLESS 1. BRI	OTHERWISE S	EDGES	USED ON BEARING SEE Pg. 1			
2. DIMENSIO	15 x 45° PR .015 NAL LIMITS APPLY A NTS	AFTER PLATING	1-08	SHEET	9 of	· q





NOTES 1. BREAK ALL SHARP CORNERS (.015/.03).

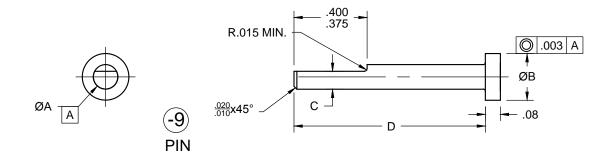
	BARN	I MA	CHIN	1E		
™ERBST2900 SWAGING 1						
DWG NO.	: (see	char	`t)-1(3	REV 2	
UNLESS OTHERWISE DIMENSIONS ARE IT		DRAWN BY: PERRITT				
TOLERANCES ON: DECIMALS		APPROVED HEAT				
	ONS ± 1/32 GLES ±.5°	TREAT FINISH SPEC	BLACK	OXIDE		
UNLESS OTHERWISE S	SPECIFIED	US	SED ON BEAR	ING		
1. BREAK ALL SHARE .015 x 45° PR .015		SEE Pg. 1				
2. DIMENSIONAL LIMITS APPLY	AFTER PLATING					
SCALE NTS	DATE 5-1	-08	SHEET 8	of	9	



TOOL#	ØA +.000 020	ØB +.005 005	ØC +.002 002	D +.002 002		MATERIA	L
RBST2936	1.625	1.165	0	0	4140 Q&T	RND. BAR	Ø1-3/4 x 1-1/8
RBST2939	1.375	.965	0	0	4140 Q&T	RND. BAR	Ø1-3/8 x 1-1/8
RBST2940	2.188	1.620	0	0	4140 Q&T	RND. BAR	Ø2-1/4 x 1-1/8

<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

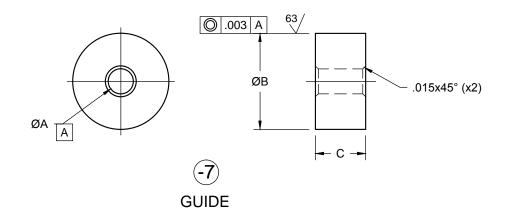
RB	RED	BA	٩R١	J MA	4CH	IN	Ε	
TITLERBST SW	2900 AGING			DP PRIM				ER
DWG NO.	TOOL#	(5	ee	cha	rt)-	-11		REV 2
	S OTHERWISE NSIONS ARE IN			DRAWN BY	: PE	RRIT	Т	
TOLERANCES		VINCILE	,	APPROVED)			
DECIMALS .XXX ± .005	EDACTI	ONS ± 1/3	32	HEAT TREAT				
.XX ± .01		GLES ±.5°		FINISH SPEC	BLA	CK 🗆	XIDE	
	OTHERWISE S	PECIFIE	D	ι	JSED ON B	EARING	3	
1. BRE	AK ALL SHARP	EDGES			SEE P	g. 1	_	_
	5 x 45° PR .015 IAL LIMITS APPLY A		ING					
SCALE N	271	DATE	5-1	-08	SHEET	7	Ωf	9



TOOL#	ØA +.000 001	ØB +.005 002	+.000 020	D +.020 020	MATERIAL
RBST2936	.129	.188	.104	.980	MCMASTER-CARR PN: 98378A909
RBST2939	.129	.188	.104	.980	MCMASTER-CARR PN: 98378A909
RBST2940	.129	.188	.104	.980	MCMASTER-CARR PN: 98378A909
L			I		

<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

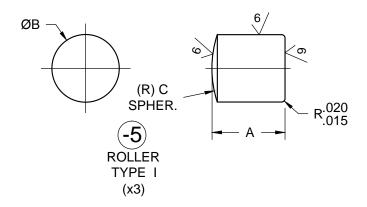
® RED	BARN	I MA	CHIN	Ε				
™LRBST2900				JLLE	ΞR			
SWAGING TOOL; PIN								
DWG NO. T.	# (see	·cha	rt)-9		REV 2			
UNLESS OTHERWISE		DRAWN BY:	PERRI	TT				
DIMENSIONS ARE I TOLERANCES ON:	N INCHES	APPROVED						
DECIMALS	IONS ± 1/32	HEAT TREAT						
.XX ± .01 ΔN	GLES ±.5°	FINISH SPEC	BLACK D	XIDE				
UNLESS OTHERWISE	SDECIEIED		SED ON BEARIN	IG				
1. BREAK ALL SHARI	PEDGES	SEE Pg. 1						
.015 x 45° PR .015 2. DIMENSIONAL LIMITS APPLY								
SCALE NTS	DATE 5-1	08	SHEET 6	of	9			

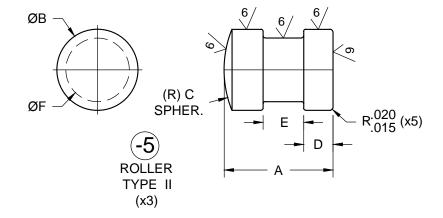


TOOL#	ØA +.001 001	ØB +.000 002	C +.000 010	MATERIA	AL.
RBST2936	.131	.372	.375	BRONZE RND. BAR	Ø3/8 x 1/2
RBST2939	.131	.372	.375	BRONZE RND. BAR	Ø3/8 x 1/2
RBST2940	.131	.622	.375	BRONZE RND. BAR	Ø5/8 x 1/2
				_	

<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

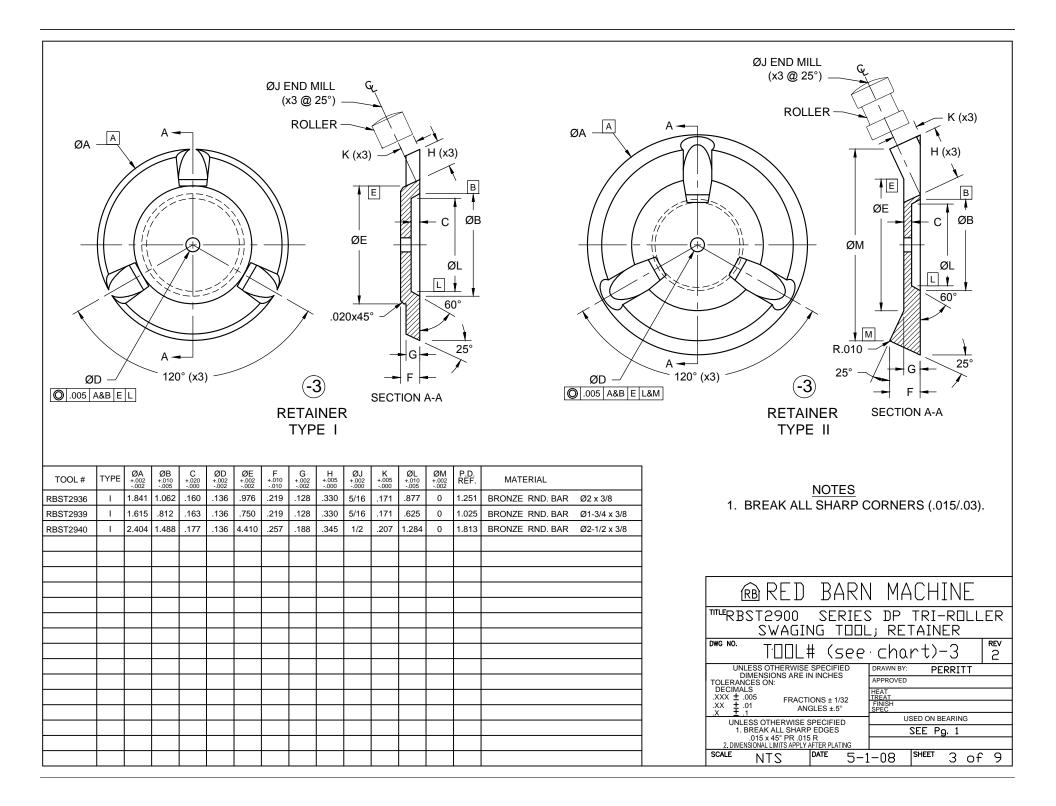
® REI) BARN	1 MA	CH.	[NE		
™ ^{LE} RBST2900 SWA	SERIE: GING TO	S DP ⁻ OL; Gl	TRI- JIDE	ROLL :	.ER	
DWG NO. T.	_# (see	· char	\t)-	-7	U AB	
UNLESS OTHERWIS		DRAWN BY: PERRITT				
TOLERANCES ON: DECIMALS		APPROVED				
.XXX ± .005 FRAC	CTIONS ± 1/32	HEAT TREAT				
	NGLES ±.5°	FINISH SPEC				
UNLESS OTHERWISI	E SPECIFIED	USED ON BEARING				
1. BREAK ALL SHA		SEE Pg. 1				
.015 x 45° PR .0 2. DIMENSIONAL LIMITS APPL						
SCALE NTS	DATE 5-	i-08 l	SHEET	5 of	٥	

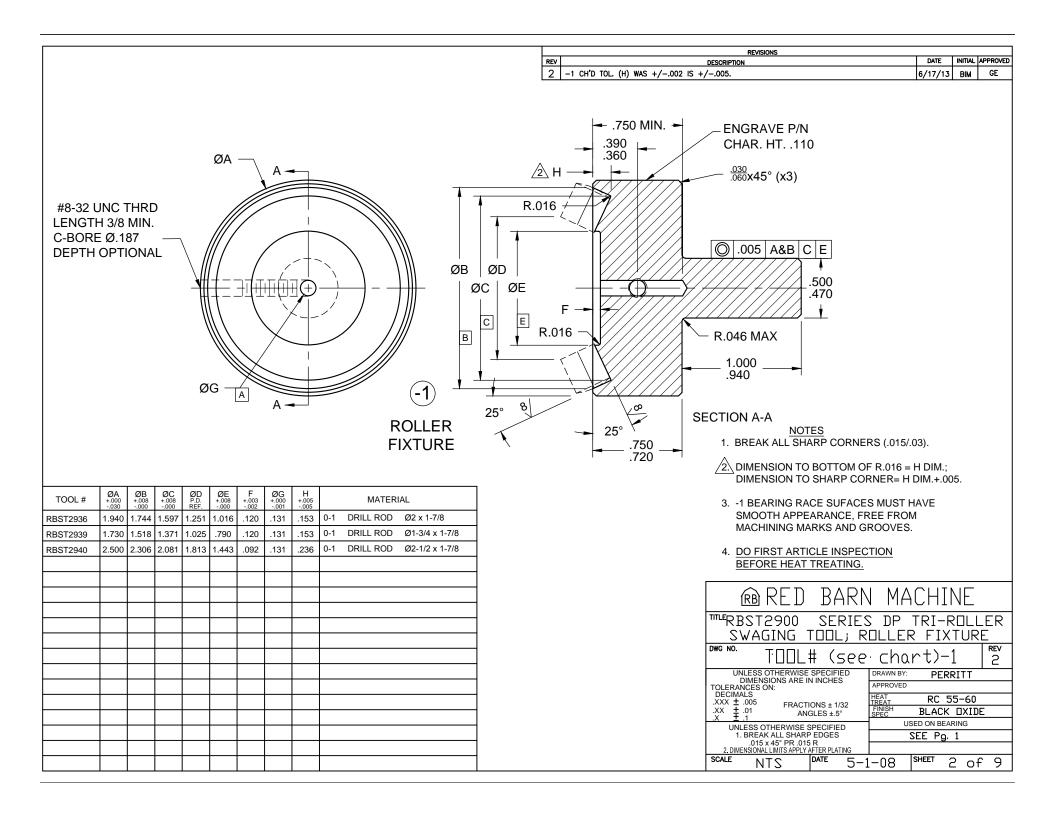




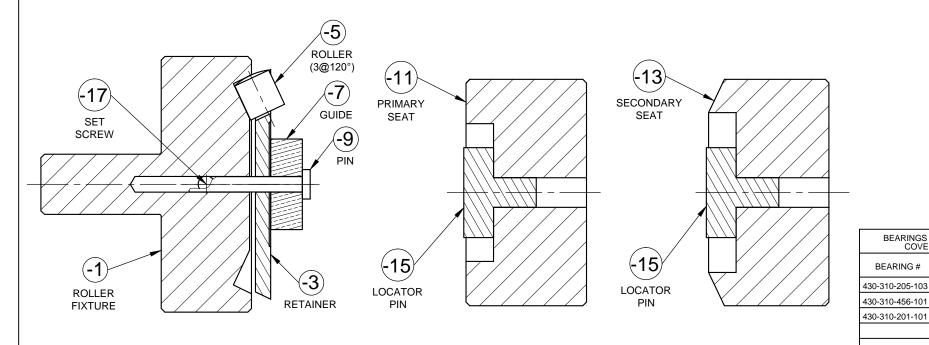
TOOL#	TYPE	A +.001 001	ØB +.001 001	(R) C +.002 002	D +.001 001	+.005 000	ØF +.000 005		MATERIAL			
RBST2936	- 1	.335	.310	.500	0	0	0	.310 MINUS	GAGE PIN	MSC#89031009		
RBST2939	I	.335	.310	.500	0	0	0	.310 MINUS	GAGE PIN	MSC#89031009		
RBST2940	ı	.378	.497	.625	0	0	0	.497 MINUS	GAGE PIN	MSC#8904970?		

® RED	BARN	I MA	CH]	N	Ε	
™LRBST2900 SWAGING T				RE TY		
DWG NO. T·□□□=	# (see	· chai	^t)-	-5		REV 2
UNLESS OTHERWISE DIMENSIONS ARE II		DRAWN BY:	PEI	RRI.	ГТ	
TOLERANCES ON:	N INCHES	APPROVED				
DECIMALS .XXX ± .005	IONS ± 1/32	HEAT TREAT				
VV I M	GLES ±.5°	FINISH SPEC				
UNLESS OTHERWISE S	SPECIFIED	USED ON BEARING				
1. BREAK ALL SHARE	EDGES	SEE Pg. 1				
.015 x 45° PR .015 2. DIMENSIONAL LIMITS APPLY						
SCALE NTS	DATE 5-1	-08	SHEET	4	of	9





П		REVISIONS									
	REV	DESCRIPTION	DATE	INITIAL	APPROVED						
	1	CHANGED -5 ROLLER RADUIS FROM .005010, TO .015020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW						
	1A	CH'D T/N'S FROM KST.	11/20/09	RJC							
	2	-1 CH'D TOL. (H) WAS +/002 IS +/005.	6/17/13	ВІМ	GE						



NOTES

- 1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- 3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

SSY	В/О	PART#	UNIT	T DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE
		-1	1	ROLLER FIXTURE	SEE CHART	2	DWG NO
		-3	1	RETAINER	SEE CHART	3] DWG NO
		-5	3	ROLLER	SEE CHART	4	ı
		-7	1	GUIDE	SEE CHART	5	TOLER
		-9	1	PIN	SEE CHART	6	.XXX
		-11	1	PRIMARY SEAT	SEE CHART	7	.XX .X
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8	U
		-15	1 or 2	LOCATING PIN	SEE CHART	9	2. DI
ſ	В/О	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S	SCALE

® RED BARN MACHINE

BEARINGS & TOOLS COVERED

TOOL#

RBST2936

RBST2939

RBST2940

BEARING #

RBST2900 SERIES DP TRI-ROLLER SWAGING TOOLS

DWG NO. REV CHART ABOVE) 2 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DRAWN BY: PERRITT APPROVED TOLERANCES ON: DECIMALS LISTED PER ITEM .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 .X ± .1 LISTED PER ITEM ANGLES ±.5° USED ON BEARING UNLESS OTHERWISE SPECIFIED SEE ABOVE

1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING SCALE

DATE 5-1-08 1 of 9 STN

	REVISIONS			
REV	DESCRIPTION	DATE	INITIAL	APPR
-		-	ı	

	REVISIONS											
REV	DESCRIPTION 2100	DATE	INITIAL	APPROVED								
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002000.	2/11/08	WP	DW								
2	CHANGED -15 LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. CHANGED -11 & -13 FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	G.E.								
3	ADDED KST2128 & KST2162. REMOVED 25' ANGLE FROM -13 SECONDARY SEAT AND DELETED ØB DIMENSION. ALSO ADDED OTY, TO -13 & -15 CHART.	4/22/08	WP									

	REVISIONS											
REV	DESCRIPTION 2000	DATE	INITIAL	APPROVED								
1	ADDED TOOL No.'s KST2014 & 2015 & 2017. ALSO ADDED -1 AUX. VEIW & ASSOCIATED DIMENSIONS WITH "J" DIM., CHANGING FROM .153 TO VARIABLE, -3 TYPE II RETAINER & ASSOCIATED DIMENSIONS, -5 TYPE II ROLLER & ASSOCIATED DIMENSIONS, -5 TYPE II ROLLER & ASSOCIATED	4/25/08	WP	DW								

® RED BARN MACHINE

Q.	TY QTY	B/O	PART#	QTY		DESCRIPTIO	ON			MAT.	B/O INFORMATION OR SPECIFICATIONS	P	g.		
			-1	1	RND			Y		6061	Ø8-1/4 x 3-7/8	2	2	DWG NO.	TRE
						_			<u> </u>						Kt
							X	`						UNLESS OTHERWISE SPECIFIED DRAWN BY: PERRITT	
							_ /							DIMENSIONS ARE IN INCHES TOLERANCES ON: APPROVED	
														DECIMALS	
						-								UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES USED ON MODEL 1. BREAK ALL SHARP EDGES	
		•	1	1	1									.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
ıΕ	ASSY #													SCALE NTS DATE 8-15-07 SHEET 1 OF	<u>f</u> :

REVISIONS											
REV	DESCRIPTION	DATE	APPROVED								

NOT APPROVED FOR PRODUCTION

			PAR	Т#	QTY		DESCRIF	PTION		
			-1	ı	1					
		DRAWN BY: PERRITT			— \ Г		$D \wedge D M$	$\Lambda \Lambda \Lambda \cap$	LITN	
		CHECKED HEAT_		(<u>RB</u>	1 [8	くヒリ	RAKIN	MAL	$\Box\Box\Box$	
		TREAT FINISH SPEC		TITLE						
[USED ON MODEL	UNLESS OTHERWISE SPECIFIE DIMENSIONS ARE IN INCHES	D							
	?	TOLERANCES ON: DECIMALS .XXX ± .005 EDACTIONS + 1						-		
ł		XX ± .005 FRACTIONS ± 1 .XX ± .01 ANGLES ±.6		DWG 1	NO.		PART	#		REV.
f		UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES)				1 1 11 \ 1	11		
		.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	3	SCALE		NTS	DATE 1-28-0	06 ^{sheet} :	l of	1